

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009330**Date Inspected:** 18-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 01

This QA inspector performed Magnetic Particle Test of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an Magnetic Particle Test report for this date. The member is identified as Counter Weight. The weld designations reviewed are as follows:

(CW001A-PP088-001,007)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 01

Flux Cored Arc Welding Process:

Welding of weld joint -001 located on PCMK CW002B-PP080. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133/WPS-B-T-2132-3.

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OBG # BAY 02

Flux Cored Arc Welding Process:

Welding of weld joint –043,044 located on PCMK FB3009-001. Welder is identified as 045280. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –016,017 located on PCMK FB3083-002. Welder is identified as 062438. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Welding of weld joint –014,015 located on PCMK FB3083-003. Welder is identified as 045203. ZPMC QC is identified as Yang Qing fang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

OBG # BAY 03

Flux Cored Arc Welding Process:

Welding of weld joint –012 located on PCMK LD003-055. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Welding of weld joint –007,010 located on PCMK LD002-046. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133.

Welding of weld joint –001,002 located on PCMK LD003-056. Welder is identified as 051356. ZPMC QC is identified as Guo yuan ting. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

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Reviewed By: Whitehead,Lonnie

QA Reviewer